

Date: Wednesday, 23/01/2008 3:33:14 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET ASSEMBLY
<b>Job Number</b> :	36949		
<b>Estimate Number</b> :	10970		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3162043
<b>This Issue</b> :	23/01/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3162 REV C
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	27348	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	30/01/2008
<b>Written By</b> :		<b>Qty:</b>	10
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A New Issue 05-11-24 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S063	6061-T6 .063 Sheet
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**Comment:** Qty.: 0.0263 sf(s)/Unit Total: 0.2625 sf(s)

6061-T6 .063 Sheet

(6061T6S063)

Batch: 100285 IB 8-1-28

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3162

\*\*\*Ensure that Grain Direction is Corect\*\*\*\*\*

Dwg Rev: C IB 8-1-28

Prog Rev: C

2-Deburr if necessary

(14)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-1-28

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5061/28 (14)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

508/01/28 (14)

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Drawing Name: BRACKET ASSEMBLY

Job Number: 36949

Part Number: D3162043

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-C'Sink as per Dwg D3162

mf 08-01-30 (14)

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3162

SB 08/01/30 (14)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/30 (14)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 8-1-30 (14)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-31 (14)

10.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21059L3	Nut Plate	M103698 (9x)

08/02/05  
M103698 (9x)

11.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS20426ad3-4	Rivet	M102404

08/02/05

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3162

08/02/05 (14)

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Drawing Name: BRACKET ASSEMBLY

Job Number: 36949

Part Number: D3162043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/02/05 (x14)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5774

AS 08/02/06 (x14)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/06 (14)

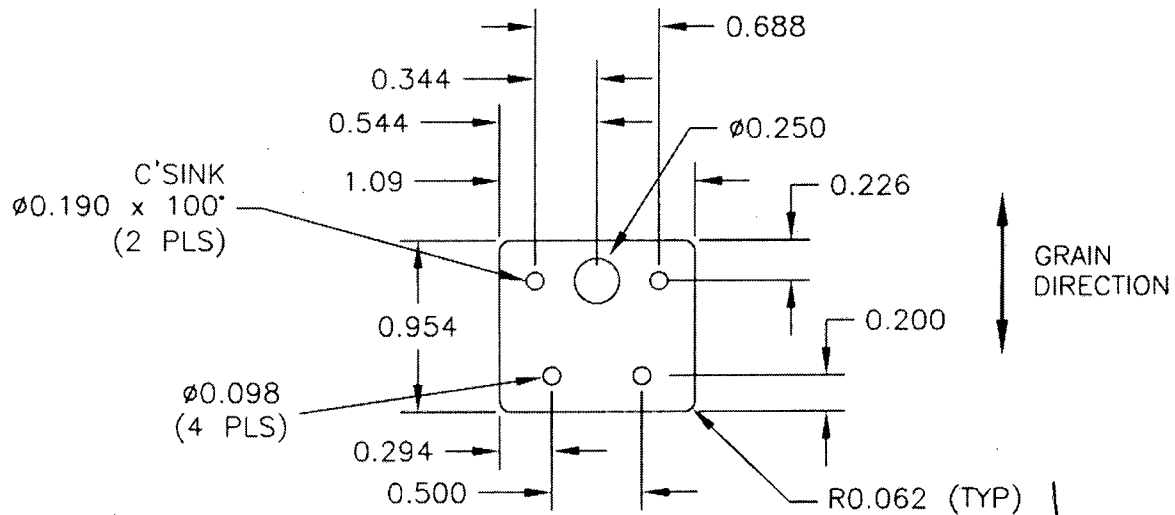
Job Completion



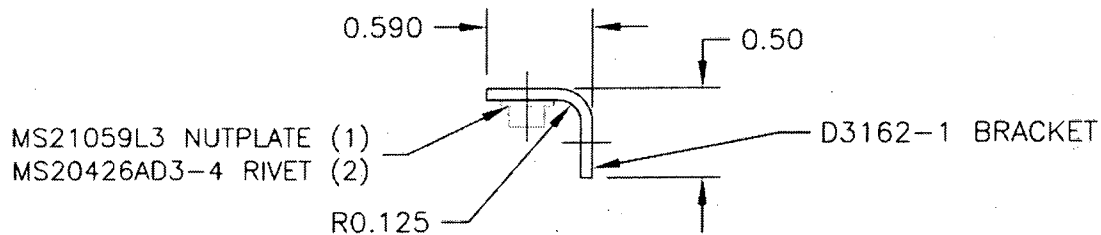
mi 2008/2/06 (14)  
W

**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3162	REV. C SHEET 1 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	
C	05.10.05	ADD D3162-3/-4	

**RELEASED**  
05.12.09

D3162-1F FLAT PATTERN  
(USED TO MAKE D3162-1 BRACKET)



D3162-041 BRACKET ASSEMBLY



**NOTES:**

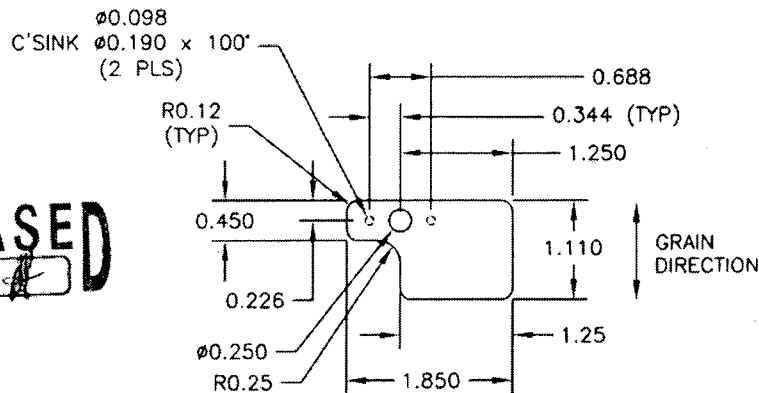
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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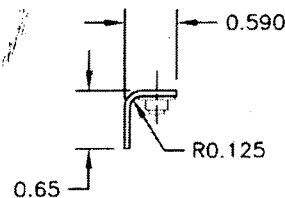
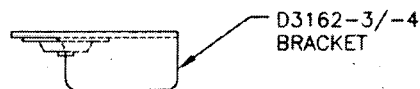
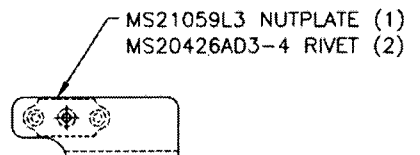
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**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3162	REV. C SHEET 2 OF 2
DATE 05.10.05		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
05.12.01

**D3162-3F FLAT PATTERN**  
(USED TO MAKE D3162-3/-4 BRACKETS)



**D3162-043 BRACKET ASSEMBLY (SHOWN)**  
(D3162-044 BRACKET ASSEMBLY (OPPOSITE))

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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